

Date: Wednesday, 28/01/2009 8:09:54 AM
 User: Chantal Lavoie

Process Sheet

| | | | | | | | |
|-----------------------|---|----------|----------------|------------------|--------------|------|-----|
| Customer | CU-DAR001 Dart Helicopters Services | | | Drawing Name | MOUNTING LUG | | |
| Job Number | 45303 | | | Part Number | D22303 | | |
| Estimate Number | 10256 | | | Drawing Number | D2230 REV F | | |
| P.O. Number | : | | | Project Number | N/A | | |
| This Issue | 28/01/2009 | S.O. No. | : | Drawing Revision | F | | |
| Prsh Rev. | NC | | | Material | : | | |
| First Issue | 11 | Type | MACHINED PARTS | Due Date | 13/02/2009 | Qty: | 200 |
| Previous Run | 44701 | | | Um: | Each | | |
| Written By | : | | | | | | |
| Checked & Approved By | : | | | | | | |
| Comment | Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|--|
| 1.0 | D2423 | Lug Extrusion Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Batch: B43722 |
| 2.0 | D22303P | LUG Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) LUG |
| 3.0 | BAND SAW | BAND SAW Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <i>cut @ 4 meter</i> |
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. |
| 5.0 | QC6 | INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 45303

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

MS 9234

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



200

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-03-H

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-04 200

10.0 POWDER COATING

POWDER COATING



M110439

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 12:00pm

OVEN TEMPERATURE: 320°K

FINISH TIME: 12:30pm

Jff 09-03-05 200

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



200

Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

BL 09-03-5

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST475

1809103/16 200

13.0 QC21

FINAL INSPECTION/W/O RELEASE



200

Comment: FINAL INSPECTION/W/O RELEASE

D 09/03/16

MS 916316

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

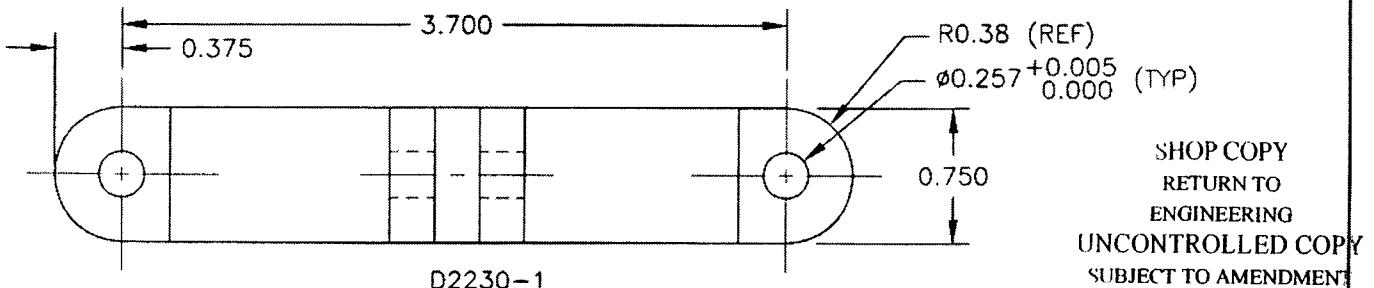
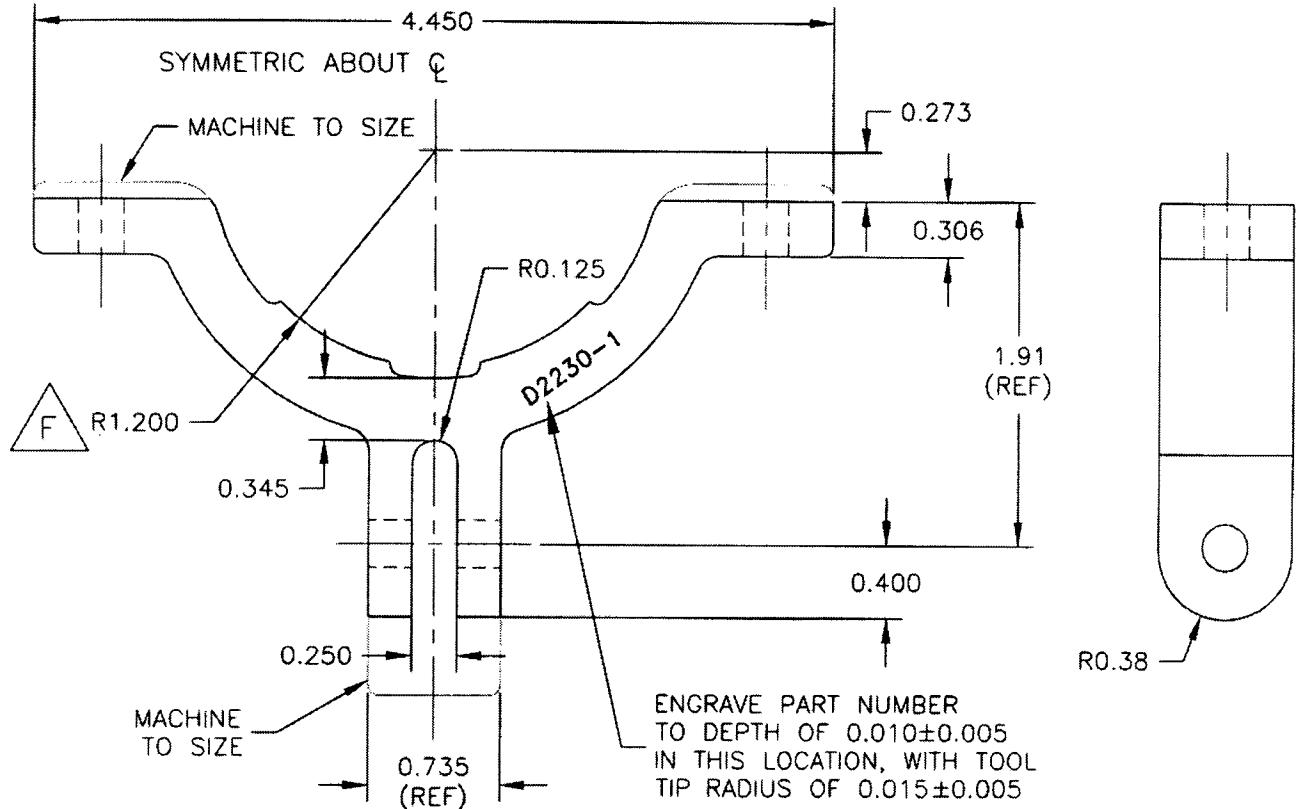
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | |
|----------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2230 REV. F SHEET 1 OF 2 |
| DATE | | TITLE MOUNTING LUG SCALE 1:1 |
| 99.12.13 | | |
| C | 94.03.30 | RE-DESIGN |
| D | 95.01.04 | RE-DESIGN |
| E | 95.01.04 | RE-DESIGN |
| F | 99.12.13 | REDESIGN; R1.200 WAS R1.100 |

RELEASED
99.12.21 B1



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

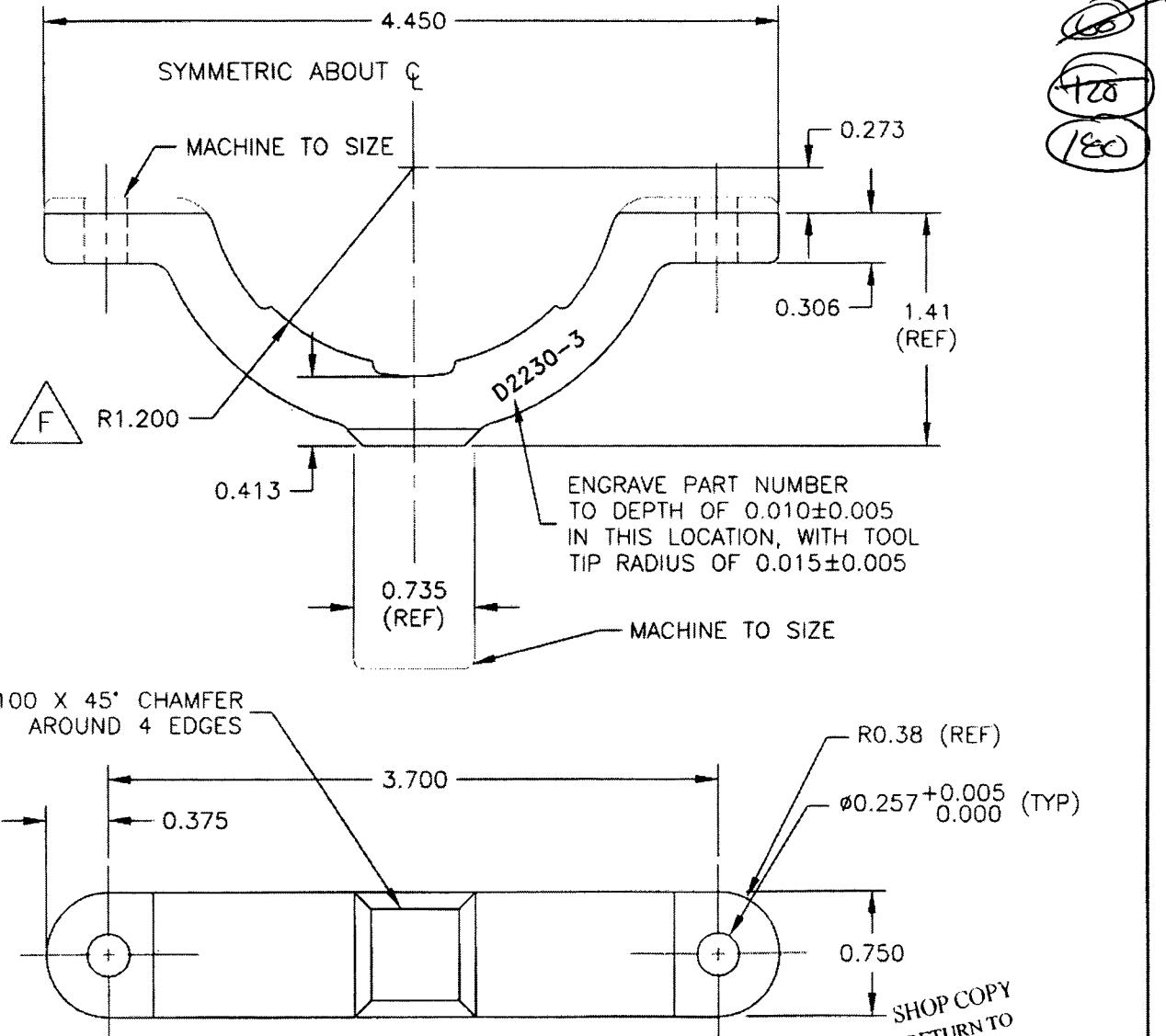
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 45303



COPY ISSUED
NO

| | | |
|---------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D2230 |
| DATE | | REV. F SHEET 2 OF 2 TITLE MOUNTING LUG SCALE 1:1 |

RELEASED
1992-12-13



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45303



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|------------------|--------------------|
| 200 | D2230-3 | Mounting Lug | 8081 |

MATERIAL: supplied by DART D2423 B43722

*Shi
03/04*

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, March 3, 2009